

Work Order ID 86191

June-22-12 1:55:02 PM

86191

Page 1

Item ID: D3535-35

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Wearshoe

Stop ***NS2***

Start Date: 22/06/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/12 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3535

Rev B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

12 0

Jm 12-6-24

FLOW CNC Waterjet

1-Cut as per Dwg D3535 Dwg Rev: B Prog Rev: B 2-

Deburr if necessary

304 .040

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

12 0

Jm 12-6-24

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

12

N 12 06 25

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Item Name: Wearshoe

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12

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

130

0.00

130

NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Deburr if necessary2-Form on Brake as per Dwg D3535 using Jigs
DT8261and DT8326.3-Identify as D3535-35.

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

150

Grey Sandtex(Ref:4.3.5.6) per QS1005 4.3

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:50 OVEN TEMPERATURE:
FINISH TIME: 1:20

Dart Aerospace Ltd

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Page 3

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Start Date: 22/06/2012 Start Qty: 12.00

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160						12	1	12-06-26	
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>FD-1</u>	0.00				12	0	12-06-26	
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12-06-27

W/O:		WORK ORDER CHANGES					
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Picklist Print

June-22-12 1:55:06 PM

Page 1

Work Order ID: 86191

86191

Parent Item: D3535-35

D3535-35

Parent Item Name: Wearshoe

Start Date: 22/06/2012

Required Date: 06/07/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	366.0693	0.8022	10.13305			

M304S20GA

304/316 .040 Sheet

**

Jm 12-6-24

Location

Loc Qty

Loc Code

001

52.4914105

121192

52.4914105

MAT020

313.577922

117933

27.3442

118400

5.3723

118964

23.2

119346

24.8

121380

49.761422

121901

183.1

121901

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DART AEROSPACE LTD		Work Order:	86191
Description: Wearshoe		Part Number:	D3535-35
Inspection Dwg: D3535	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.000	+/-0.010	1.998"	✓		✓	mmor
1.885	+/-0.010	1.883"	✓		✓	"
6.00	+/-0.030	5.998"	✓		✓	"
6.75	+/-0.030	6.752"	✓		✓	"
Ø0.188	+0.005/-0.001	0.190"	✓		✓	"
23.250	+/-0.010	23.250"	✓		MT	HBOI
19.750	+/-0.010	19.750"	✓		MT	"
17.750	+/-0.010	17.750"	✓		MT	"
14.250	+/-0.010	14.250"	✓		MT	"
9.500	+/-0.010	9.499"	✓		✓	Produtor
4.750	+/-0.010	4.749"	✓		✓	mmor
0.300	+/-0.010	0.303"	✓		✓	"
0.300	+/-0.010	0.303"	✓		✓	"
0.038	+/-0.010	0.035"	✓		✓	"

Measured by: JM	Audited by: [Signature]	Prototype Approval:	N/A
Date: 12-6-24	Date: 12-06-25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	[Signature]

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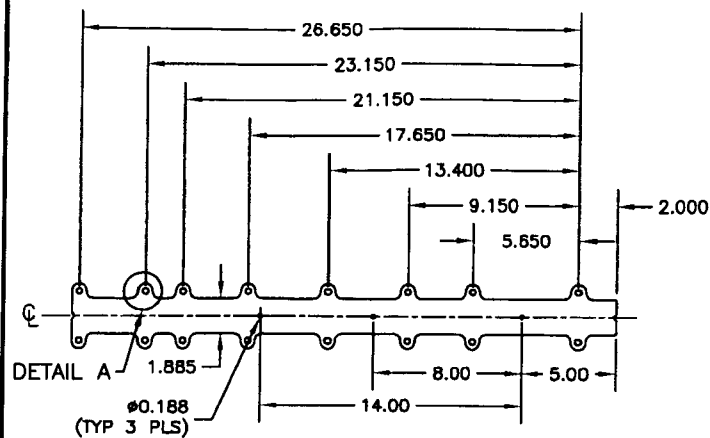
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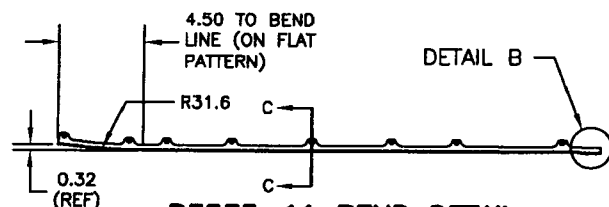
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07.04.24

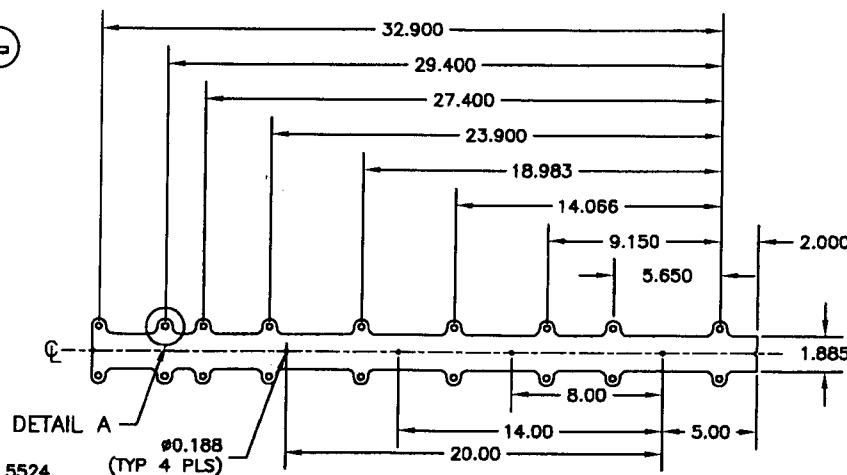
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86191 MLJ
12/06/22



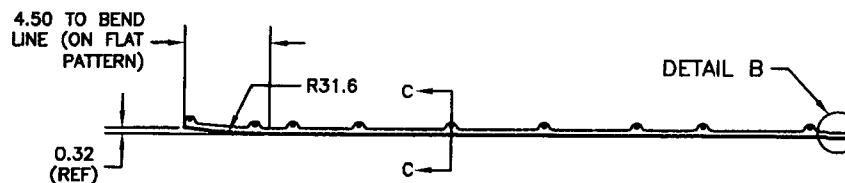
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
PH	PH	D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 1 OF 7
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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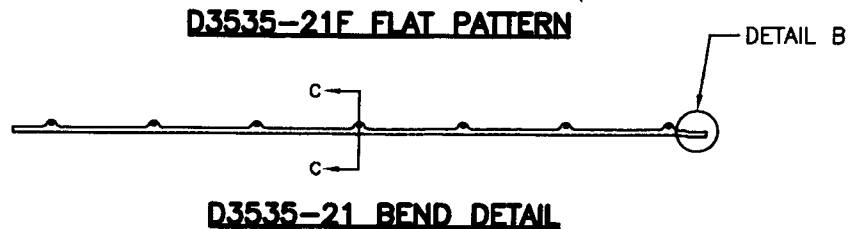
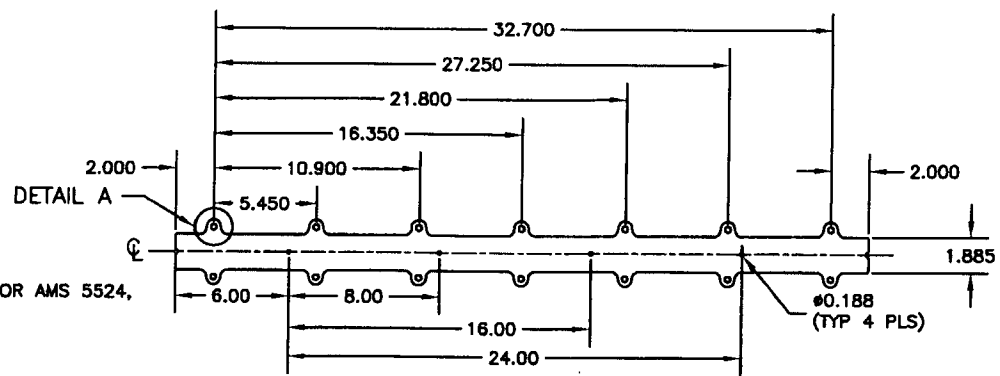
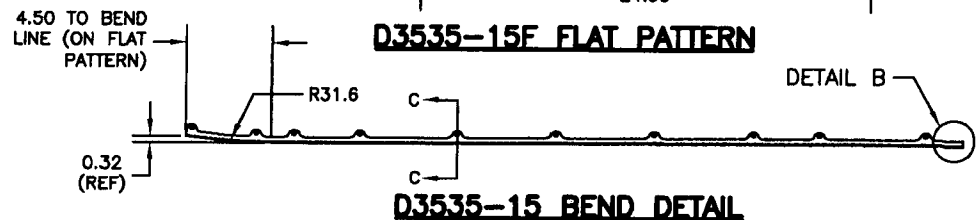
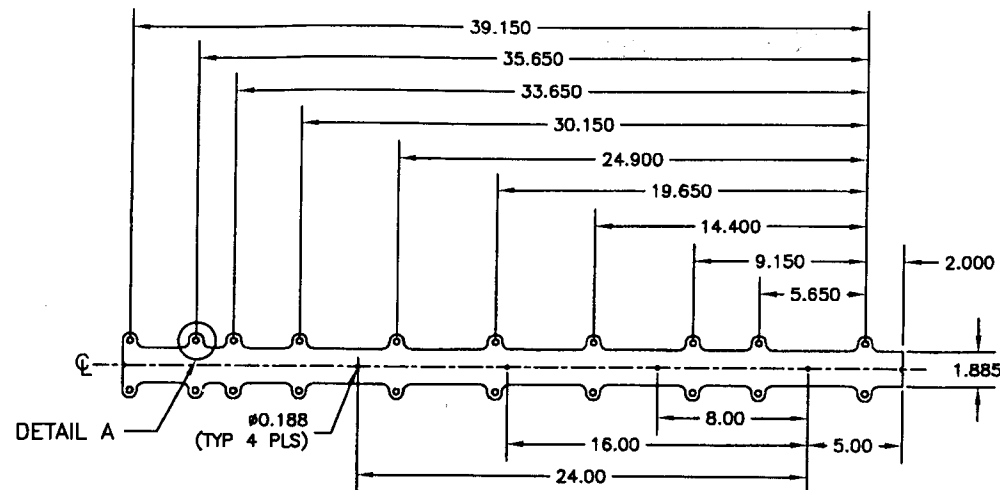
NOTE: Date & initial all entries

86191

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07.04.24

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 2 OF 7
	SCALE 1:10	



- NOTES**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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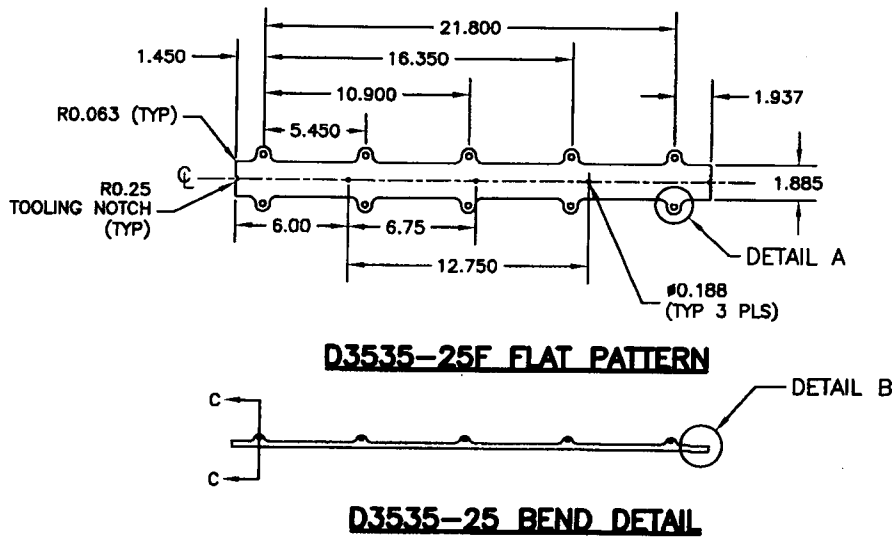
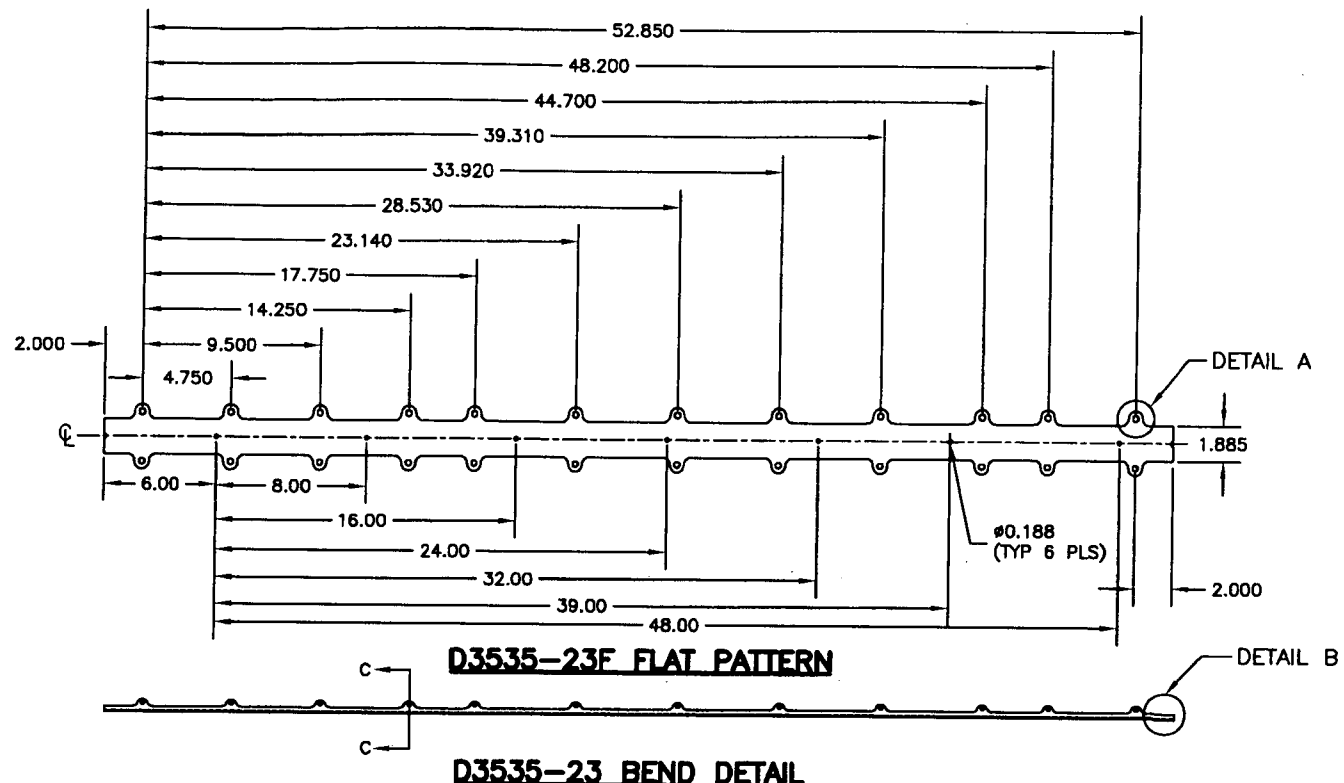
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07.04.24

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CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 3 OF 7
		SCALE	1:10	



NOTES

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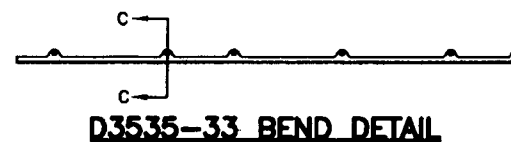
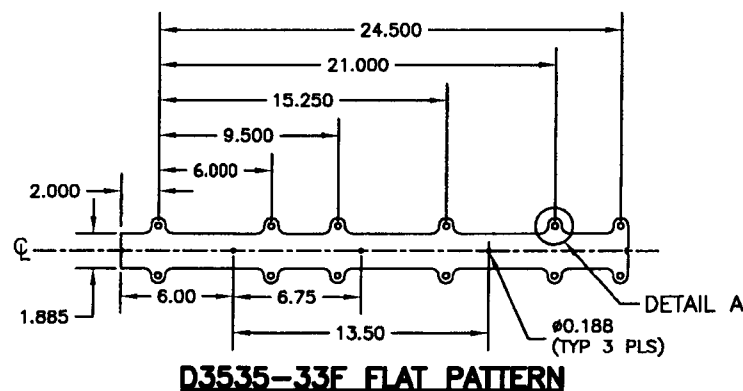
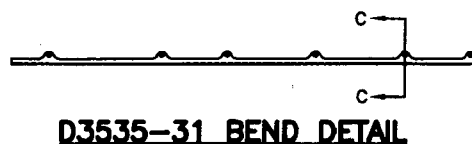
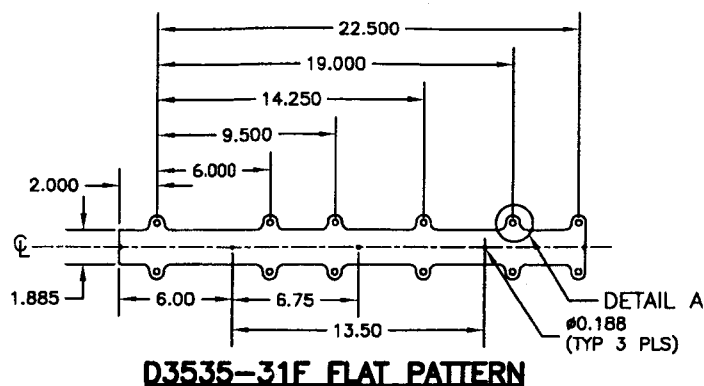
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 4 OF 7
		SCALE	1:10	

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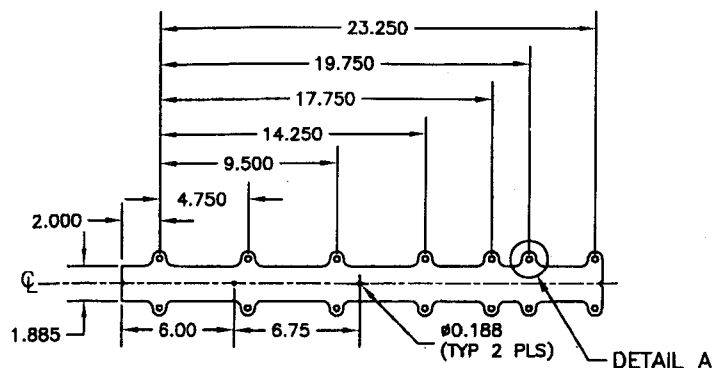
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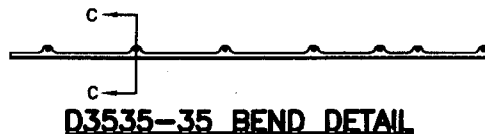


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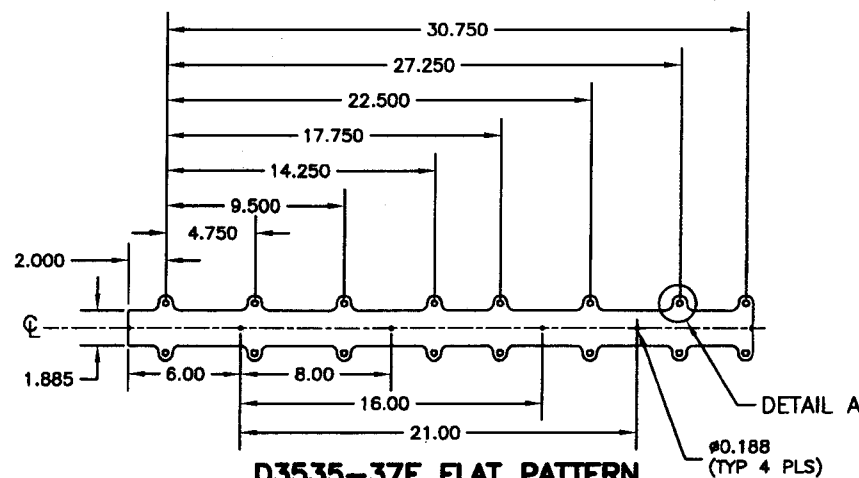
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CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 5 OF 7
		SCALE	1:10	



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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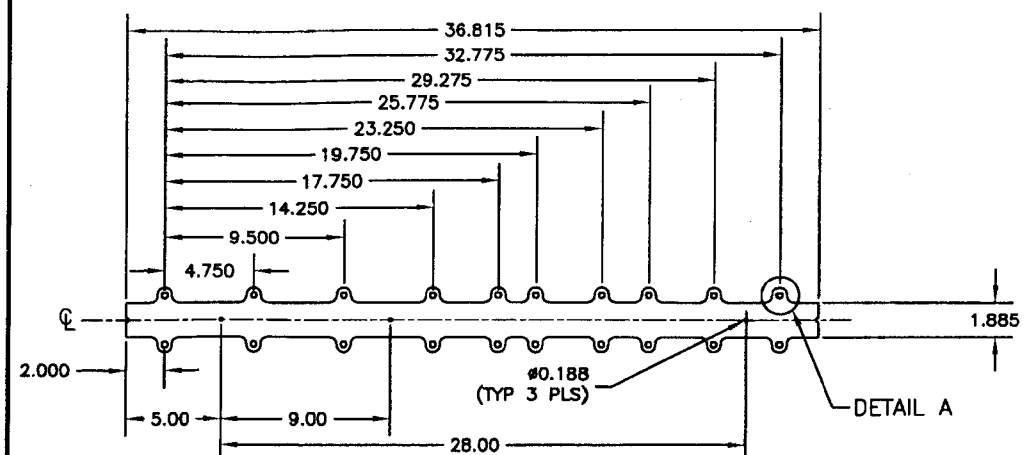
NOTE: Date & initial all entries

06191

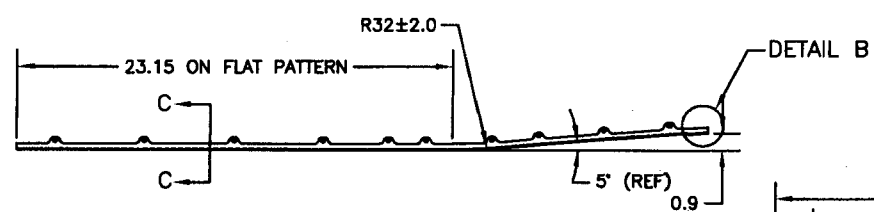


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07.04.17

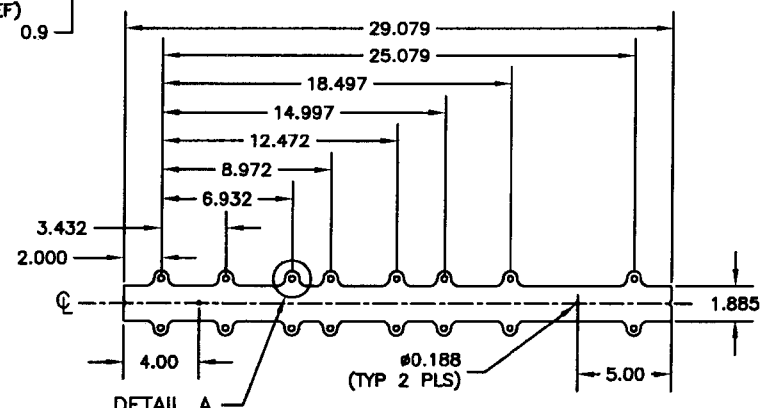
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	REV. B
DATE 07.04.17	DRAWING NO. D3535	SHEET 6 OF 7
	TITLE WEARSHOE	SCALE 1:10



D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

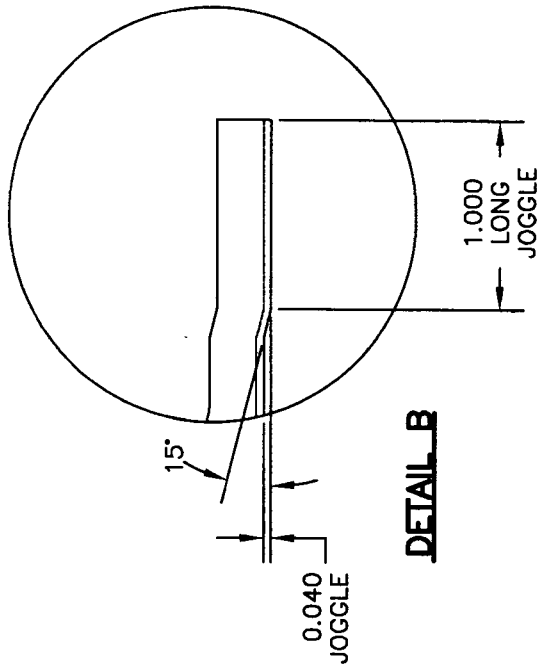
NOTE: Date & initial all entries

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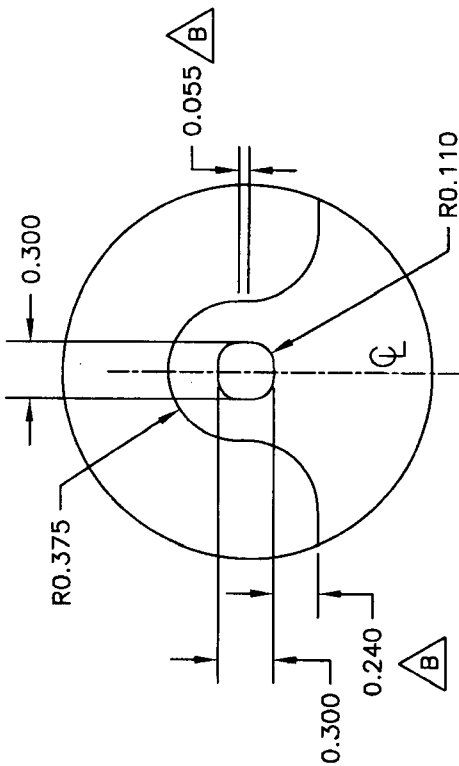


DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17	TITLE WEARSHOE		SCALE 1:1

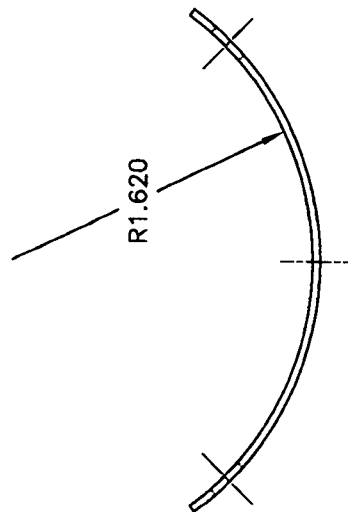
RELEASED
07.04.24



DETAIL B



DETAIL A



SECTION C-C

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries